



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4634-1

Job Sheet 183477



Part No: D4634-1

Job Qty: 2 ea

Part Name: Fwd, Center Ceiling Panel



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/18/18

Job Tracking No:

Due Date: 10/12/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV G SHEETS 10,11,16,17 IPP Rev. A 12/08/09 New Issue DL IPP Rev B 12/11/08 Document release
DL VERIFIED BY:JLM IPP Rev C 13/07/09 Dwg Update DL verf: DD IPP Rev D Dwg Update 13/12/23 DL IPP
REV E Dwg update 14/01/09 DL IPP Rev F Dwg. update 14/02/03 DL IPP Rev G Dwg. Update 15/01/27 DL

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Purchasing	2 pcs		10/12/18	0.00	0.00	Purchasing		OCT 12 2018
140	Packaging	2 pcs		10/12/18	0.00	0.00	Packaging2		OCT 12 2018
150	QC	2 pcs		10/12/18	0.00	0.00	QC6		AT 10/15
170	Packaging	2 pcs		10/12/18	0.00	0.00	Packaging3		21 OCT 15 2018
180	QC21-SA	2 Ea		10/12/18	0.00	0.00	QC21		21 OCT 15 2018

Part Op 140 - Receive & Inspect for Damage & Mat'l Certs
Descriptions: 150 - QC6- All purchased or subcontracted products
170 - Identify as per dwg & Stock Location:
180 - QC21- Final Inspection - Work Order Release

PO 041067 x 2 RH SEP 19 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4634-1P	Fwd, Center Ceiling Panel	2 pcs (1 ea)	110-Purchasing	5117963
MLEXS.093-F6006-07	GE Plastics Lexan Sheet (Light Grey)	34.6000 sf (17.3 ea)	110-Purchasing	5117965

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Purchasing	D4634-1P	2	1	0
	MLEXS.093-F6006-07	35	2,104	0

Part Specifications



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

could not be found.

Plex 9/18/18 3:16 PM Dart.lajeunesse.marie

Container No: S117967



Part: D4634-1

Job No: 183477

Serial No/Batch: S117967

Revision: G

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/12/18

DQA: _____ Date: _____

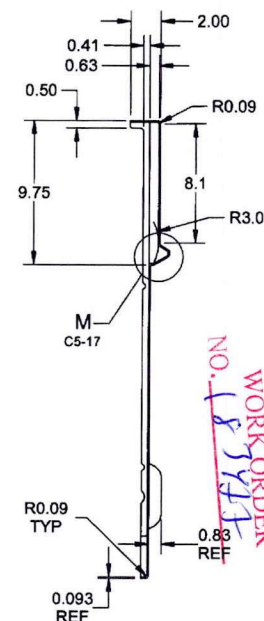
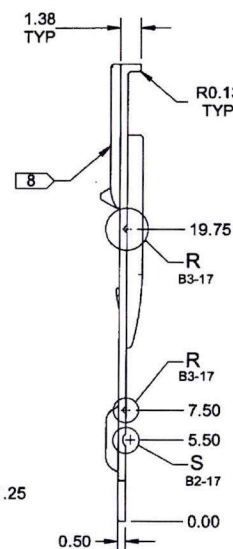
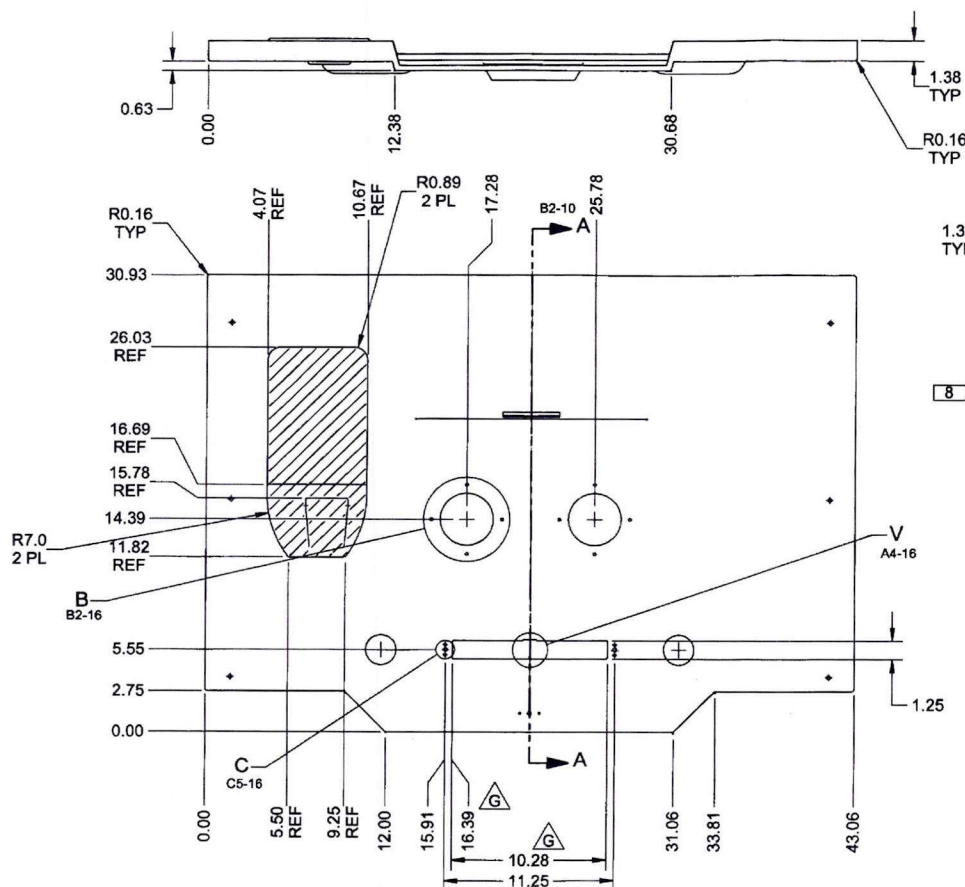


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					



SECTION A-A C6-10

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 155473

NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
(REF DART SPEC MLEXS.093-F6006-07)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 5.65 lbs
- 8) TEXTURE ON THIS SIDE
- 9) 0.14 RADIUS NOT SHOWN FOR CLARITY
- 10) DRILL & TRIM D4634-1 PER TOOL DT9836
- 11) THERMOFORM PER QSI 022 USING DT9844 TOOL
MIN. THICKNESS AFTER FORMING:
SHADED AREA = 0.020
EDGES = 0.060
ELSEWHERE = 0.070
- 12) LOCATE Ø2.030 AT CENTER OF PROTRUDED SURFACE AS SHOWN

D4634-1 FWD, CENTER CEILING PANEL

RELEASED

2015 JAN 26

APPROVED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AK	DRAWING NO.	REV. G
MFG. APPR.	DL	D4634	SHEET 10 OF 17
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CENTER CEILING PANELS	NTS
DATE	14.11.28	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041067**

Supplier: PLA002-VC
Plas-Tech
115 Applewood Crescent
Concord
ON
L4K 5C1 Canada
Phone: 416-736-0004
Fax: 416-736-0010

PO No: PO041067
PO Date: 9/19/18
Due Date: 10/10/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Lussier, PatrickPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	183477	D4634-1P			Fwd, Center Ceiling Panel : Various STC's As Per DWG D4634 REV. G	Firmed	-	10/10/18	2 pcs	0 pcs	2 pcs	\$180.00/pcs	\$360.00
2	183456	D3690-1P			Glareshield : Various STC's As Per Dwg D3690 Rev. C	Firmed	-	10/10/18	1 pcs	0 pcs	1 pcs	\$526.00/pcs	\$526.00

Grand Total: \$886.00

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY
A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
A049 SUPPLIER AWARENESS

Plex 9/19/18 11:10 AM dart.Lussier.Patrick



115 Applewood Crescent
Concord, ON, L4K 5C1
PLASTECHONLINE.COM

P- 416 736 0004
F- 416 736 0010

Packing Slip

Shipment Number: 31651
Shipment Date: 10/11/2018
BOL Number:
Customer Key: C1887
Salesperson: MIKE AUBE
Page Number: 1 of 1

B DART AEROSPACE LTD.
I 1270 ABERDEEN STREET
L HAWKESBURY ON K6A 1K7
L CA
T Attn: DALE BATES
O Buyer Contact: ROBERT ABOUD

S DART AEROSPACE
H 1270 ABERDEEN STREET
I HAWKESBURY ON K6A 1K7
P CA
T Attn: PATRICK LUSSIER
O

Purchase Order

41067

Sales Order

SO-025500

Incoterms

EX WORKS

Payment Method

COL

Carrier Account #

151793240

Ship Via

FEDERAL EXPRESS - Priority Overnight

Tracking Number

773455708517

Item Number
Revision

D4634-1P Rev.: G

Description

FWD, CENTER CEILING PANEL

Quantity
Shipped

2 EA

UOM

Number of Containers

Gross Weight

Shipped By

Certificate Of Conformance



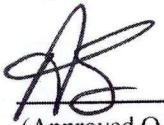
Customer: DART AEROSPACE LTD

P.O. # 41067 ✓

SO # 025500

Part #	<u>D4634 - 1P</u> ✓	Qty.	<u>2</u> ✓	Batch #	<u>-001</u>
Description	<u>FWD, CENTER CEILING PANEL</u>	Material usage	<u>1 SHEET</u>	Lot#	<u>0007424014</u>
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	

Note: All parts are not identified as meeting QSI044.

By: 
(Approved QA Signatory)

Date: OCT. 11, 2018 C O F C # 086

Page: 1 of 1